

Tuesday, 4/17/2007 9 AM  
Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FWD TUBE ASSEMBLY  
 Job Number : 31855  
 Estimate Number : 10467  
 P.O. Number : *N/A*  
 This Issue : 4/17/2007 S.O. No. : *N/A*  
 Prsht Rev. : NC  
 First Issue : *N/A* Type : MACHINED PARTS  
 Previous Run : 31852  
 Part Number : D3391021  
 Drawing Number : D3391 REV.F  
 Project Number : N/A  
 Drawing Revision : F  
 Material : *N/A*  
 Due Date : 5/30/2007 Qty: 1 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est. A 05.09.13 New issue KJ/JLM  
 Est. B 06.02.10 Dwg rev.D ecn 773 EC  
 Est. C 06.05.02 Added inspections EC  
 est D 07.03.13 rev F dwg EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D6013047 SKIDTUBE MAT'L



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 SKIDTUBE MAT'L

Pick:

Qty Part Number Description Batch  
 1 D6013-047 Extrusion

*B 26547*

*119*

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1  
 Cut extrusion to 46.52 +0.010 -0.020

*BE C7*

3.0 BENDING BENDING MACHINE



Comment: No bender  
 Bend as per Dwg D3391 Using Bend Prog 3391021

*EL 7-5-7*

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*DP 7-5-8*

5.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 1-Machine as per Folio FA590 Rev. *AA* & Dwg D3391 Rev. *F*  
 Identify as D3391-1

2-Deburr

*07/05/15*

*(1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31853

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/05/15

(1)

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391

BG 07-05-22

(1)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG 07-05-22

(1)

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

GMR 07/05/22

(1)

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill and c/sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)  
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Deburr

7-5-23

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2005-25 11

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Jb 7-6-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31853

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-L* 07-07-14 (1)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*m 104/144* *an-H* *BP 07-07-19*

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*U 7/24*

16.0

NAS1330C3KB166

INSERT



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Rivnut

Pick:

Qty

Part Number

Description

Batch

14

NAS1330C3KB166

Insert

*M 102849*

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

*AL* 07-07-24 (1)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*1707/24* (1)

19.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3401-041

Tow Cap

*B31346*

*1707-0724* (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31853

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE

B 31398

Y1

21.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
GASKET

B 32660

22.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

AN3C4A

Bolt

M 104955

Y1

23.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

4

NAS1515H3L

Washer

M 104603

Y1

24.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

washer

M 105057

Y1

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install tow Cap as per Dwg D3391

Identify as D3391-021

Y1 07-07-24

26.0

QC5

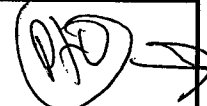
INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect thread of each insert using DT8824

inspect to current step



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/07/24	26	Change to inspect to current step	En	07/07/24			En 07/07/24

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Tuesday, 4/17/2007 11:10:09 AM

Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31853

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PPP

33528

6/7/30

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Done

Job Completion



U 8-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

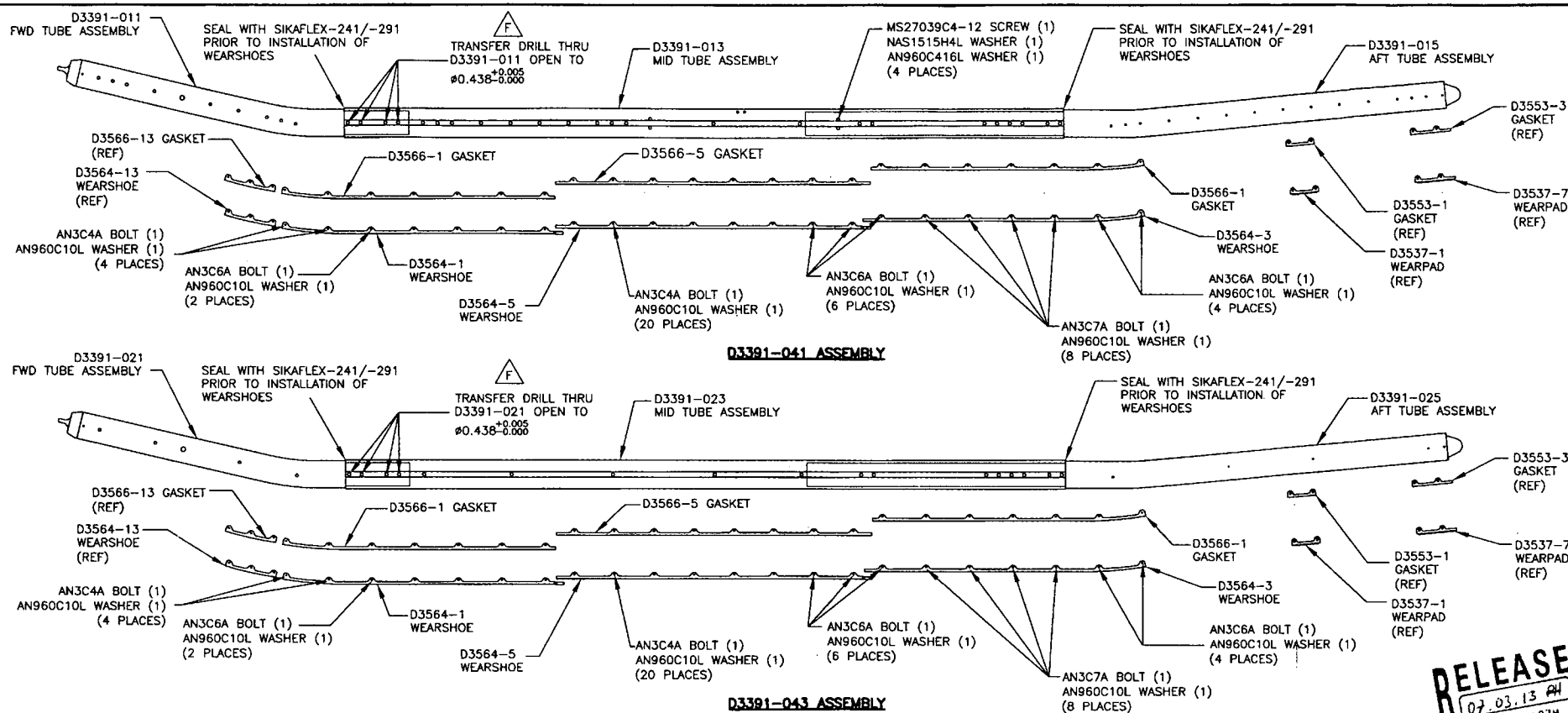
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







#### D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3566-1	WEARSHOE
1	1	D3566-3	WEARSHOE
1	1	D3566-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

#### GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DTB217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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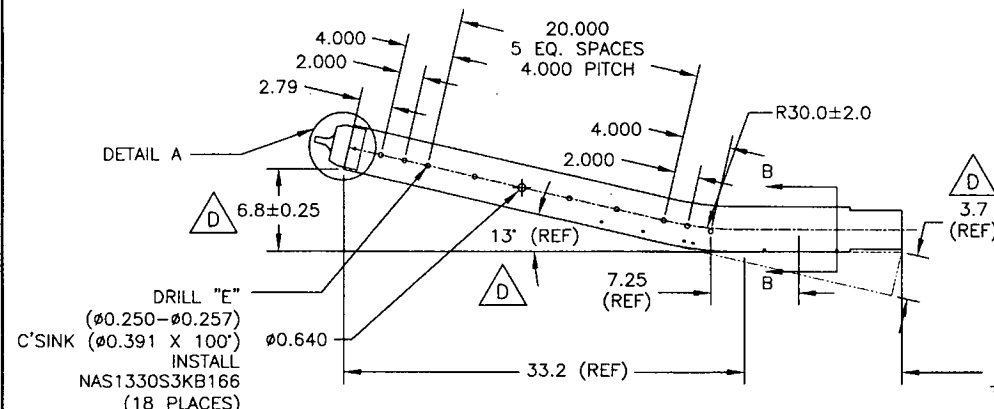
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F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	APPROVED	DRAWING NO. D3391
DATE		TITLE 412 FLOAT SKIDTUBE
07.01.18		SCALE NTS

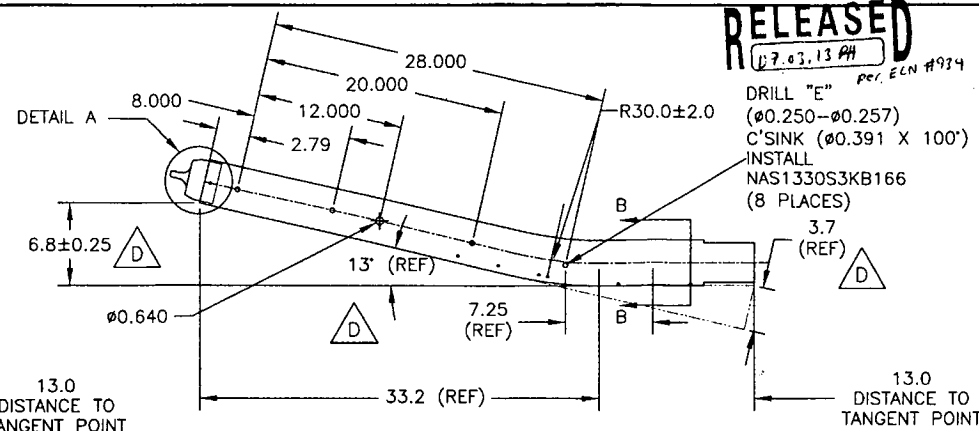
1/853  
CONTROLLED COPY  
RETURN TO  
SUPPLY



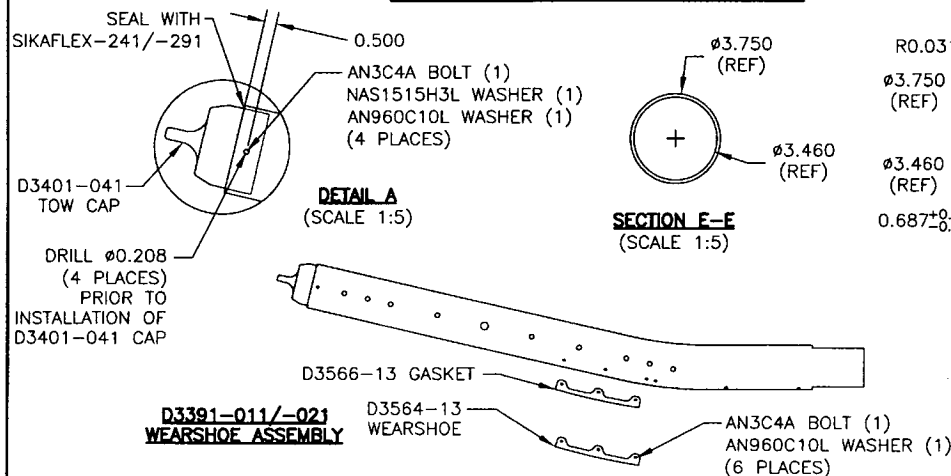
**RELEASED**  
17.03.13 AH  
REF. EGN #934



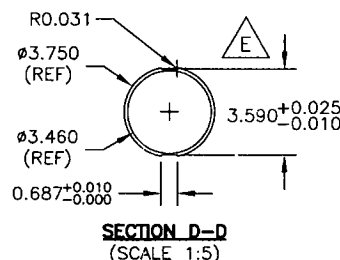
**D3391-011 ASSEMBLY AND BENDING DETAIL**



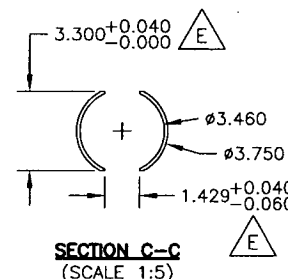
**D3391-021 ASSEMBLY AND BENDING DETAIL**



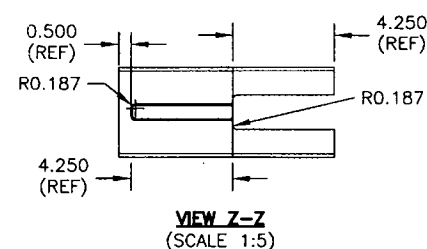
**D3391-011/-021 WEARSHOE ASSEMBLY**



**SECTION D-D (SCALE 1:5)**



**SECTION C-C (SCALE 1:5)**

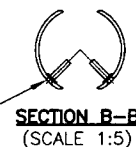


**VIEW Z-Z (SCALE 1:5)**

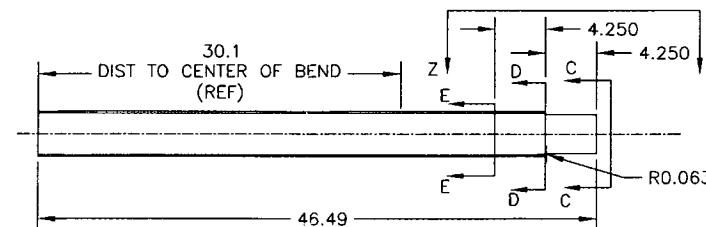
**D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST**

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

5  
DRILL "E"  
(Ø0.250-Ø0.257)  
C'SINK (Ø0.391 X 100')  
INSTALL  
NAS1330S3KB166  
(12 PLACES)



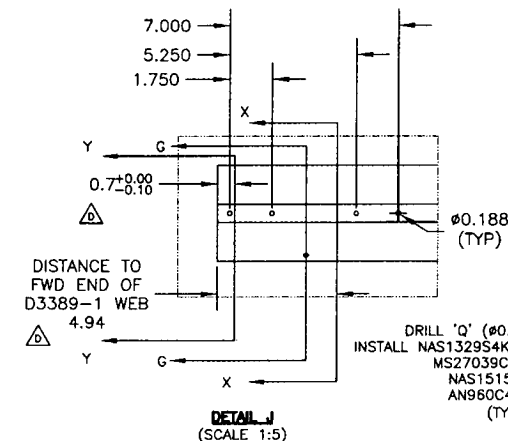
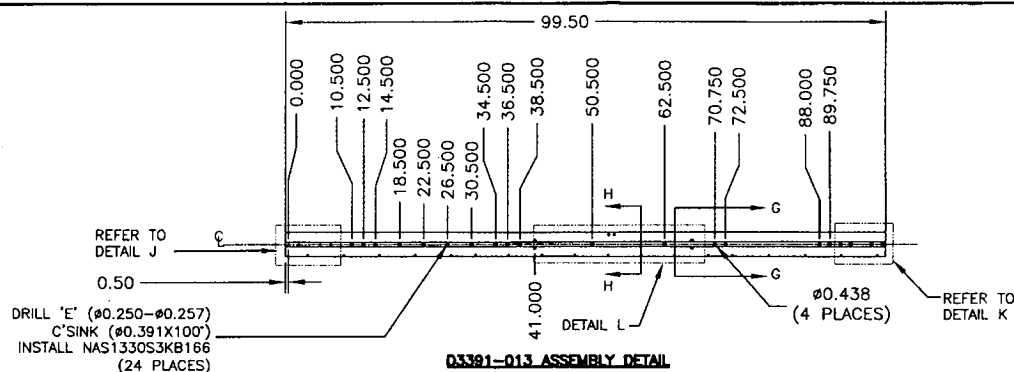
**SECTION B-B (SCALE 1:5)**



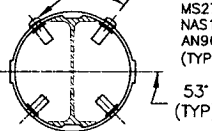
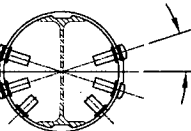
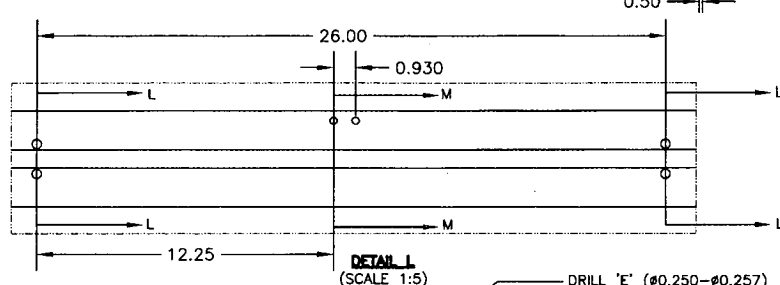
**D3391-1 DRILLING AND CUTTING DETAIL (MAKE FROM D6013-047 SKIDTUBE MATERIAL)**

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DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		REV. F SHEET 2 OF 5 SCALE 1:10

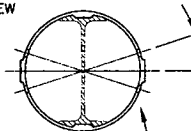
UNCONTROLLED COPY  
SUBJECT TO AN ENGINEER  
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3/18/13



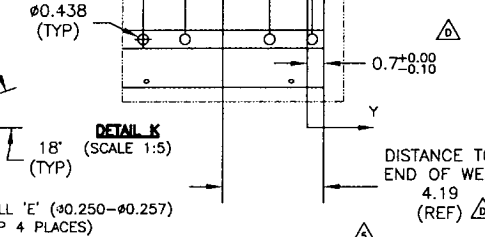
DRILL 'Q' (#0.332-#0.338)  
INSTALL NAS1329S4KB140 INSERT  
MS27039C4-08 SCREW  
NAS1515H4L WASHER  
AN960C416L WASHER  
(TYP 4 PLACES)



DRILL 'E' (#0.250-#0.257)  
C'SINK (#0.391X100)  
INSTALL NAS1330S3KB116 INSERT  
MS27039C1-09 SCREW  
NAS1515H3L WASHER  
AN960C10L WASHER  
(TYP 4 PLACES)



DRILL 'E' (#0.250-#0.257)  
(TYP 4 PLACES)

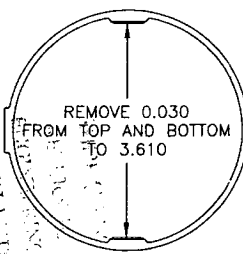


**D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X	X	D3391-013	MID TUBE ASSEMBLY
		D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3KB116	INSERT (OR NAS1330C3KB116)
24	10	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1329S4KB140	INSERT (OR NAS1329C3KB140)
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

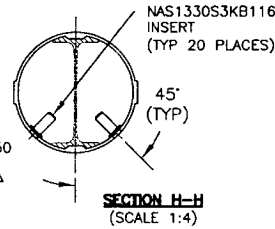
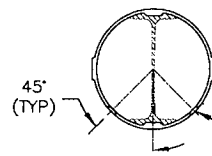
**D3391-013/-023 MID TUBE ASSEMBLY**

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015



REMOVE 0.225  
FROM TOP AND BOTTOM  
TO 3.800  
(0.7 FROM BOTH ENDS)

**SECTION Y-Y**  
(SCALE 1:4)



**RELEASED**  
07.03.13 RH  
DCI ECU #934

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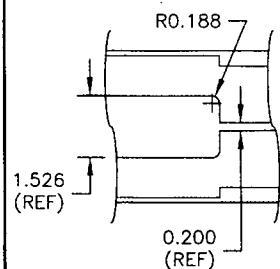
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DESIGN  
CHECKED  
DATE  
07.01.18

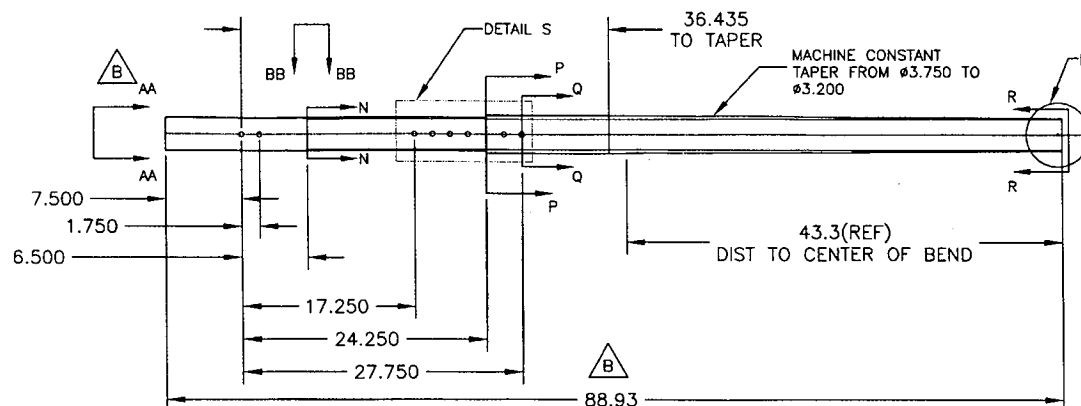
DRAWN BY  
APPROVED  
TITLE  
412 FLOAT SKIDTUBE

**DART** DART AEROSPACE USA, INC.  
PORT HADLOCK, MA  
DRAWING NO.  
D3391  
REV. F  
SHEET 3 OF 5  
SCALE  
1:20

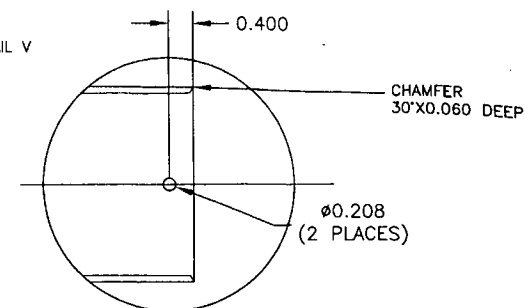




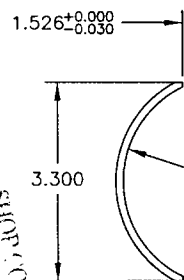
VIEW BB-BB  
(SCALE 1:3)



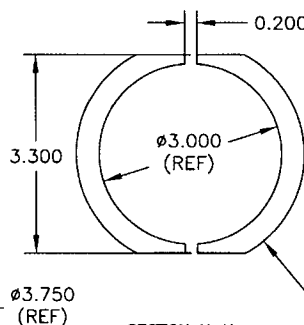
D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



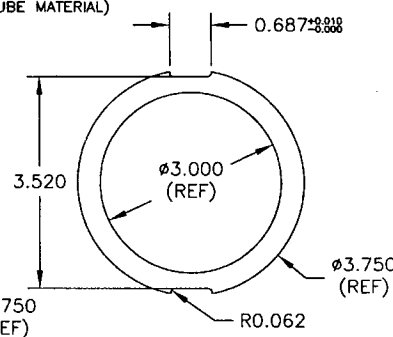
DETAIL V  
(SCALE 1:2)



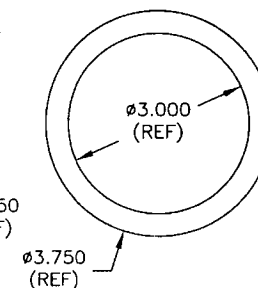
SECTION AA-AA  
(SCALE 1:2)



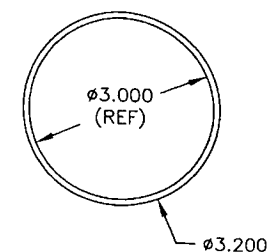
SECTION N-N  
(SCALE 1:2)



SECTION P-P  
(SCALE 1:2)

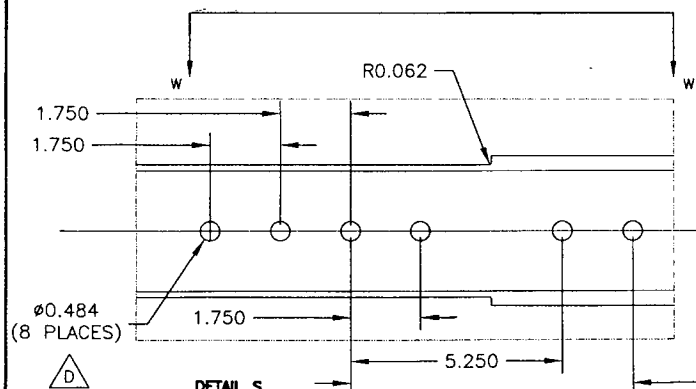


SECTION Q-Q  
(SCALE 1:2)

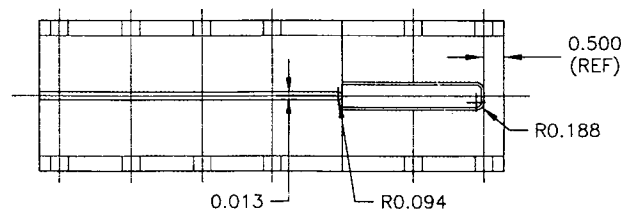


SECTION R-R  
(SCALE 1:2)

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SUBJECT TO ANY  
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DETAIL S  
(SCALE 1:3)



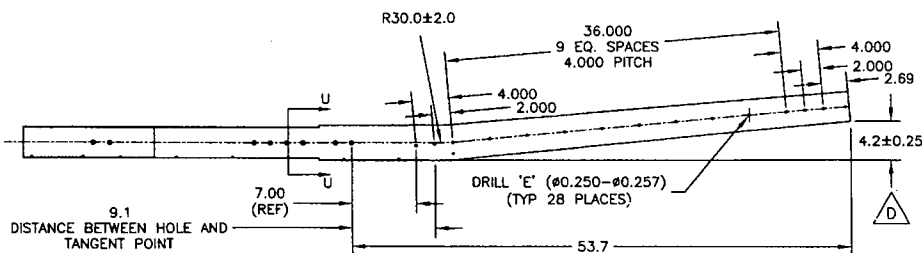
VIEW W-W  
(SCALE 1:3)

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07-03-13 PH  
per ECU #934

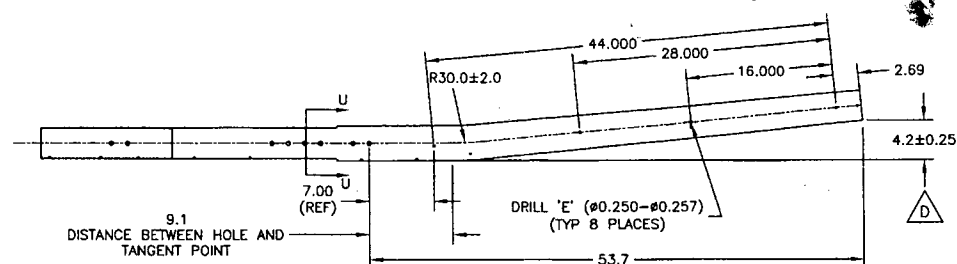
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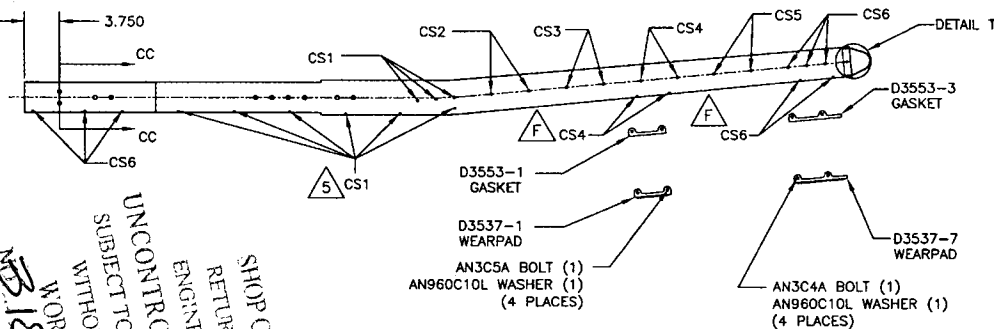
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. F
CHECKED H	APPROVED H	DRAWING NO. D3391	SHEET 4 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	



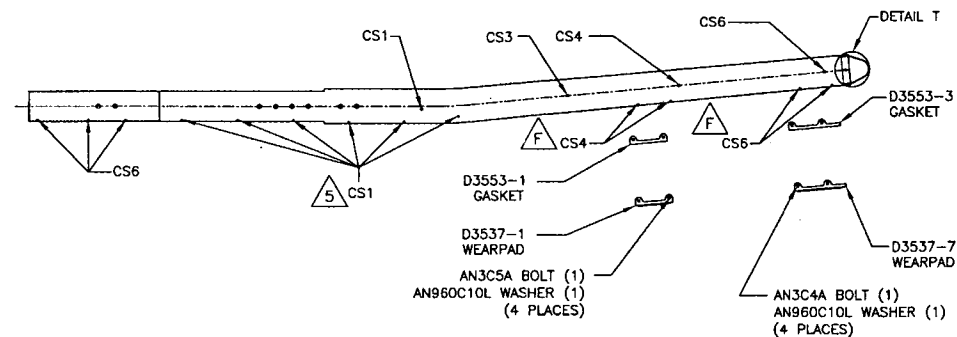
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



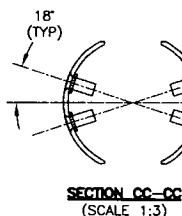
D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL  
(SEE TABLE)



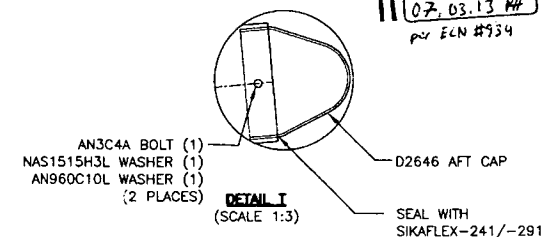
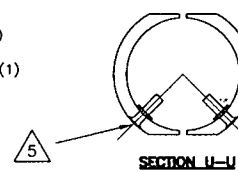
D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL  
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER



DRILL 'Q' (#0.332-#0.338)  
C'SINK (#0.529X100")  
NAS1330S4KB151 INSERT (1)  
(4 PLACES)



C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	REV. F SHEET 5 OF 5 SCALE 1:12

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per ECU #934

